

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-011878**Date Inspected:** 25-Jan-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lv Li Qing**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #14

This QA Inspector observed the following work in progress:

SMAW in the 4F position for the OBG Segment 11DW, weld No.SP506-001-064. The welder is identified as #047864. ZPMC QC is identified as Mr. Li Ming Yang . The welding variables recorded by QC appear to comply with WPS-B-P-2114-FCM-1.

FCAW in the 3G position for the OBG Segment 11DW, weld No.SEG071A-010. The welder is identified as #202122. ZPMC QC is identified as Mr. Li Ming Yang . The welding variables recorded by QC appear to comply with WPS-B-T-2233-Tc-U4b-F.

FCAW in the 1F position for the OBG Segment 11DW, weld No.SP507-001-015. The welder is identified as #201215. ZPMC QC is identified as Mr. Li Ming Yang . The welding variables recorded by QC appear to comply with WPS-B-T-2131.

Ultrasonic Testing (UT)

WELDING INSPECTION REPORT

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This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as portion of Segment 7EW.

The Weld Designations are as follows

SEG041C-003,004,007,008,017,018

SSD13-PP60-002,003,009

SSD13A-PP60-002,007

SSD13A-PP59-108,128,131,134,127

SSD13A-PP59-002,003,009

During the Quality Assurance Ultrasonic Testing (UT) review of welds located on Orthotropic Box Girder (OBG) segment 7EW, this Quality Assurance Inspector (QA) discovered that One (1) longitudinal linear indication measuring approximately 25mm in length. The indication db's rating is a +7. Material thickness is 14mm. The depth of the indication is approximately 5mm. The weld is identified as SEG041C-018 and located at Panel Point PP59 Cross Beam Side. The weld is designated as Non Seismic Performance Critical Material (Non SPCM). The indication is clearly marked on or near the weld. The Y distance for this indication is 230mm from top. The weld is a Complete Joint Penetration (CJP) "T" joint joining Longitudinal diaphragm Plate X69M (Non SPCM) to Floor Beam Plate X48B (Non SPCM).

This QA Inspector generated an incident report for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera, Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson, Rodney	QA Reviewer
